

Date: Friday, 04/04/2008 9:22:09 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FWD X-TUBE
Job Number :	38399		
Estimate Number :	10006		
P.O. Number :		Part Number :	D2889
This Issue :	04/04/2008	Drawing Number :	D2889 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	B
Previous Run :	38398	Material :	
Written By :		Due Date :	30/04/2008
Checked & Approved By :	<u>30 08.4.4</u>	Qty:	1 Um: Each
Comment :	Est Rev:A New Issue 05-10-25 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6005180	Crosstube material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Crosstube material

Pick:

Qty	Part number	Description	Batch
1	D2889	Fwd Crosstube	B23963

DP

8-4-8

2.0	BENDING	BENDING MACHINE - SKIDTUBES
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Comment: LANDING GEAR RESOURCE 1
 1-Bend D2889 as per Dwg D2889 and Folio FT001

DP

8-4-8

3.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

N/A

1-Deburr and Polish

4.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

S 08/04/08

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Acid etch and alodine as per QSI 005 4.1
 Inside and outside of tube

N/A
 37945

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 04/04/2008 9:22:09 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE

Job Number: 38399

Part Number: D2889

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

u/a *08/04/09*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

used on w/o # 57245

08/04/09

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/14

Job Completion



u 08-04-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

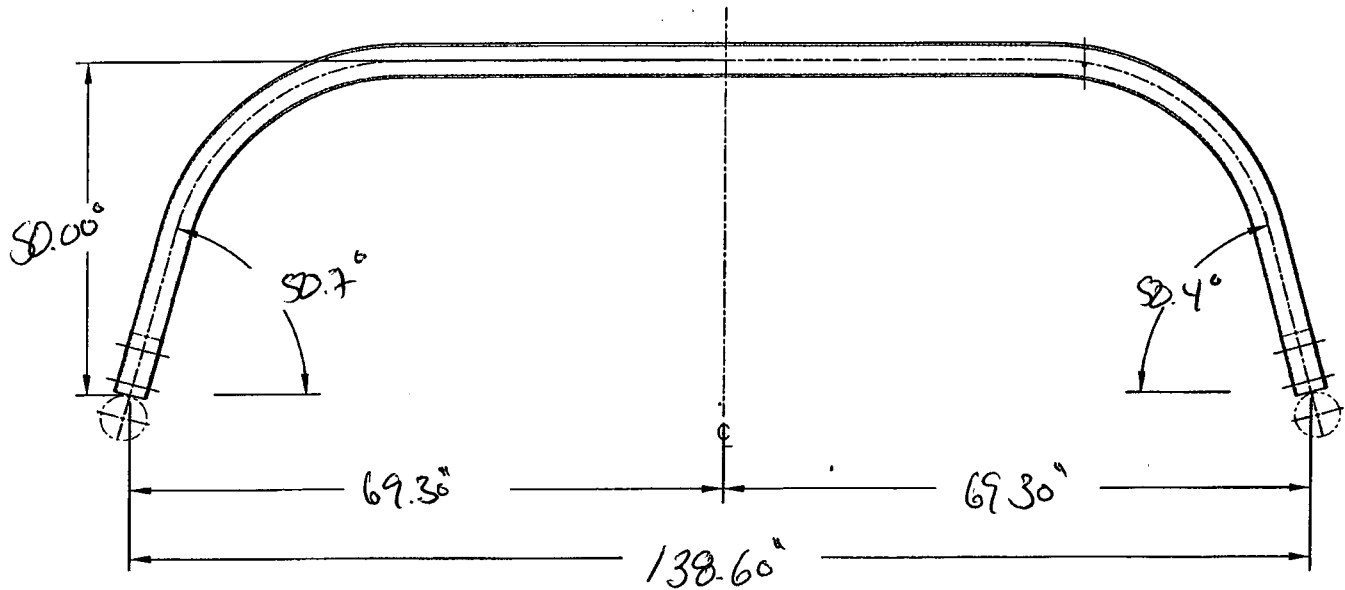
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38399
Description: Crosstube Fwd		Part Number:	D2889
Inspection Dwg: D2889		Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments
* used on w/o # 37945

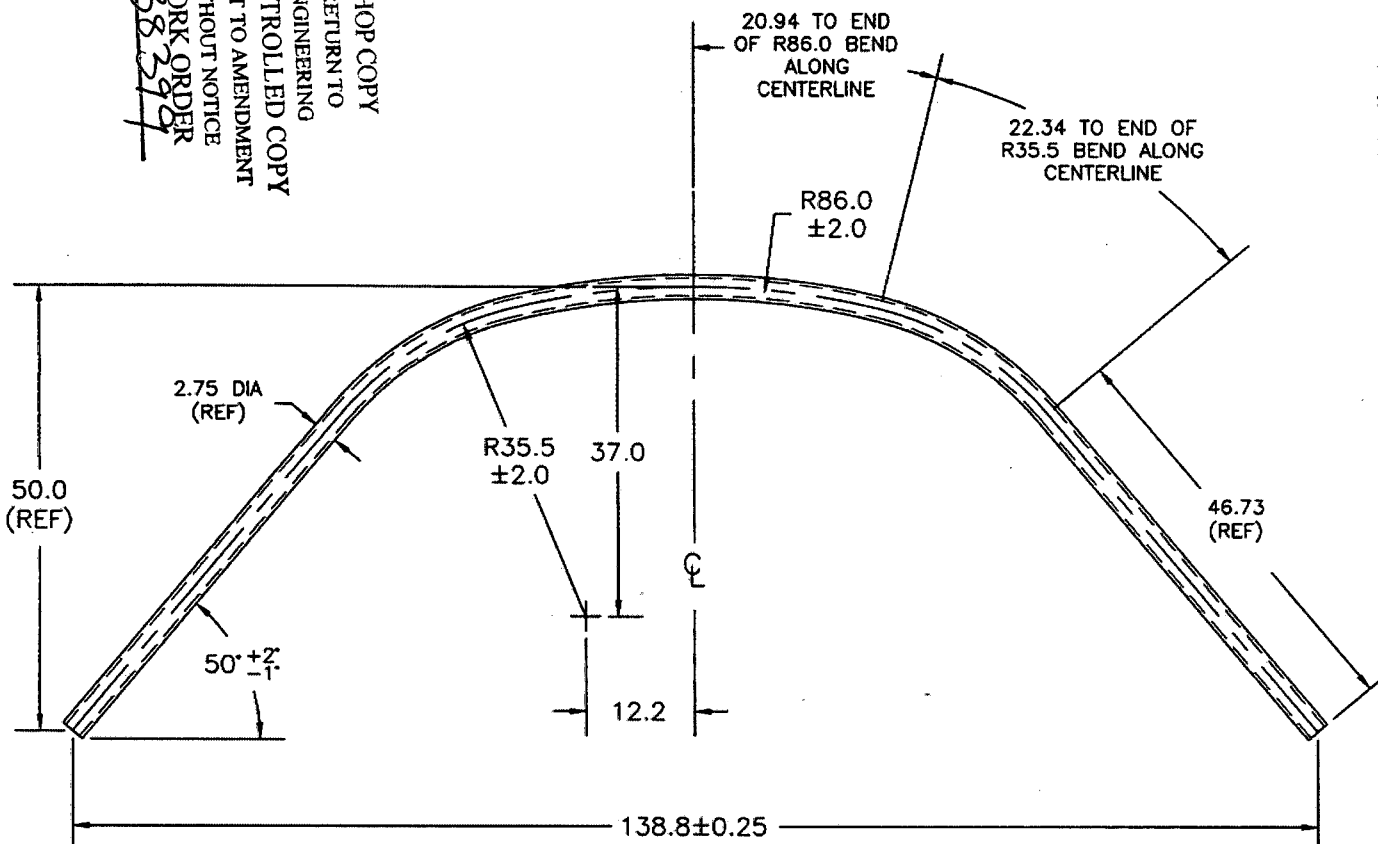
QC15 Inspection	
Date	08/04/09

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	



RELEASED
02.10.28

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
#	CP	DRAWING NO.	REV. B
CHECKED #	APPROVED #	D2889	SHEET 1 OF 1
DATE	TITLE	SCALE	
02.10.18	FWD CROSSTUBE	1:20	
A	99.05.21	NEW ISSUE	
B	02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES	



NOTES

- 1) MATERIAL: MANUFACTURE FROM D6005-180 ($\phi 2.75$ OD x 0.375 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

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WORK ORDER
NO. 38399

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